



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2563
Job Sheet 166892



Part No: D2563

Job Qty: 4 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/19/17

Job Tracking No:

Due Date: 10/30/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	4 Ea		10/27/17	0.00	0.00	Start Up Large Fab2	<i>CPC</i> AUG 27 2017
100	Large Fab	4 pcs		10/27/17	0.00	5.88	Large Fab 2	<i>CPC</i>
110	QC	4 pcs		10/27/17	0.00	0.00	QC9	
120	QC	4 pcs		10/27/17	0.00	0.00	QC5	
130	HandFinish	4 pcs		10/27/17	0.00	1.07	HandFinish1	<i>2017/10/30 JSL</i>
140	QC	4 pcs		10/27/17	0.00	0.00	QC7	<i>CPC</i>
150	Large Fab	4 pcs		10/28/17	0.00	5.88	Large Fab 2	<i>CPC-DAS</i>
160	QC	4 pcs		10/28/17	0.00	0.00	QC10	<i>38 DAS</i>
170	QC	4 pcs		10/28/17	0.00	0.00	QC5	<i>3-89 38</i>
175	HandFinish	4 pcs		10/28/17	0.00	1.07	HandFinish2	<i>2017/11/01 JSL</i>
180	Powdercoat	4 pcs		10/28/17	0.00	0.67	Powdercoat1	<i>BL</i>
190	HandFinish	4 pcs		10/30/17	0.00	1.07	HandFinish3	<i>DAS</i>
200	QC	4 pcs		10/30/17	0.00	0.00	QC3	<i>38</i>
210	Packaging	4 pcs		10/30/17	0.00	0.00	Packaging3	<i>SD 9-89</i> NOV 10 2017
220	QC21-SA	4 Ea		10/30/17	0.00	0.00	QC21	<i>DAS</i>

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & Descriptions: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: _____

M 138014 START: 2:45 O.U.T 370° FINISH: 3:15.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2244-116 → <i>B150064-1</i>	4	41	0	0
	D2561 → <i>B166297</i>	8	19	0	0
	D2564 → <i>B166325 x 5</i>	8	23	0	0
	D2673-34 → <i>B160473</i>	4	40	0	0
150-Large Fab	D2673-34 → <i>B160473</i>	4	40	0	0

Part Specifications

Specifications could not be found.

RED: M136158

Plex 10/19/17 1:41 PM dart.Michaud-Febrille.Victoria

AUG 27 2017

CPC

AUG 23 2017

3:30 A 4:30

1-

DAS
24
9-89

AUG 24 2017

7:00 A 9:00

2

9-89

AUG 24 2017

1:45 A 2:45

1-

AUG 26 2017

1:15

4:30

3:25

9:75

2.5

2.5

DART
AEROSPACE

S001405



Step Weldment Assembly

PART NO:

D2563

Revision:

Operation:

Quantity:

Change No:

Start up Operation
4

Mfg Date: 10/23/17
Job No: 166892

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com